

Work Order ID 54952



Page 1

January 5, 2010 10:43:35 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube L.H

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RF*

Date: 10-1-05 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

5 10/01/06

H for MF 10/01/25

54952

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54952

January 5, 2010 10:43:35 AM



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Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod

M112860

BE 10/01/07

10-Grind welds flush as per Dwg D2750

BE 10/01/07

10/1/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 10/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

12- Scribe batch# inside per dwg D2750

BE 10/01/07

120

QC10- Inspect visual per QSI004- ground welds

0.00



2) 8.10.01.07

QC

Memo

0.00

Quality Control



130

QC5- Inspect part completeness to step on W/O

0.00



2) 8.10.01.07

QC

Memo

0.00

Quality Control



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



MB 10-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

[Signature]

10-1-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 112385

exp. date: 10-01-11

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: m112860

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

Handwritten: 10-01-11

Handwritten: AWM 10-01-11

Handwritten: BE 10/01/12

Handwritten: AML

Handwritten: 10-01-13

Handwritten: 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

36 10/01/12

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

=> 8/10/01/14

(tt)

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> 8/10/01/14

(L)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00

Handwritten: 10/01/18



HandFinish

Memo

0.00



Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Handwritten: 10-01-18



Powdercoat

Memo

0.00



Powder Coating

START TIME: *9:00 AM*
OVEN TEMPERATURE: *370°F*
FINISH TIME: *9:30 AM*

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Handwritten: 10-01-19



Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 54952

January 5, 2010 10:43:35 AM



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Item ID: D350-636-011

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Setup Start



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Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

BR 10-01-19

230



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: _____

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 112345

EXP DATE: 10/08

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M 101223

5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

BR 10-01-19 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 54952



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January 5, 2010 10:43:35 AM

Item ID: D350-636-011

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Item Name: Skidtube LH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



⇒ 8/10/120

QC

Memo

0.00

(+)

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

10-1-21 (R) SP

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



⇒ 8/10/126

QC

Memo

0.00

(+)

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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January 5, 2010 10:43:35 AM

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

0.00

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

NEU-H

280



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/2010

10/01/2010

MF 10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:39 AM

Page 1

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3		Manufactured	No			230	Each	362.0000	8.0000			

Q-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	27	
51613	27	
Main Warehouse		
ST	335	
52562 ✓	335	

D2744	Manufactured	No				110	Each	60.0000	1.0000			
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Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
44892	1	
47488	23	
51922	36	

8 265,0-00-16

1 11011/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	16.0000	1.0000			
Extrusion Bent												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	5	
50675	5	
Main Warehouse		
ST	11	
43495	1	
47133	1	
52346	9	

1 K10/116

D2743 Manufactured No

160 Each 299.0000 8.0000



Crossbolt Spacer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	94	
50281	50	
51913	44	
Main Warehouse		
ST	205	
44891	2	
45555	17	
48275	1	
52310	185	

B BE 10/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Alt Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739		Manufactured	No			160	Each	5.0000	1.0000			
350 I Beam												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
47124	1	
53900	4	

B-55034 AWM
10-1-11

D3490-3		Manufactured	No			160	Each	37.0000	4.0000			
Cross Bolt Spacer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	37	
45560	1	
48276	31	
51930	5	

4 BE 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	84.0000	4.0000			



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	84	
45338	2	
47657	22	
48277	20	
51932	40	

4 BE 10/01/12

ALS4-1032-225

Purchased

No



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6691	
10744i	16	
110768 ✓	6675	

38 BL 10-01-19

D3492-041

Manufactured

No



Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	76	
51584 ✓	76	

8 BL 10-01-19

January 5, 2010 10:43:39 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:39 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3		Manufactured	No			230	Each	16.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 16

51592 12

51903 ✓ 4

AN8C35A

Purchased

No

230

Each

137.0000

1.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 137

102180 1

106896 1

110105 48

110847 ✓ 87

1 BL 10-01-19.

1 BL 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:39 AM

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH


Start Date: 05/01/2010

Required Date: 18/01/2010


Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
* D3793-1  Wearshoe		Manufactured	No			230	Each	19.0000	1.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	19	
40551	1	
51597	16	
51906 ✓	2	

D3488-041  Blade Fitting Assembly, LH		Manufactured	No			230	Each	14.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	14	
47348 ✓	14	

1 PR 10-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:39 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3		Manufactured	No			230	Each	21.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	18	
51598 ✓	6	
51907	12	
Main Warehouse		
ST	3	
46531	2	
47440	1	

1 BR 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A		Purchased	No			230	Each	148.0000	4.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	146	
110105	4	
110155	14	
110665	1	
111605	50	
111649	50	
112720	9	
113121	18	

MS21083C8

Purchased

No

230

Each

53.0000

1.0000

NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
110584	5	
111424	2	
112492	6	
113149	40	

4. 10-01-19

1 10-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25		Manufactured	No			230	Each	40.0000	1.0000			



Gasket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP10	35	
51607 ✓	9	
54479	26	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

1 BR 10-01-19.

D3631-1

Manufactured No

230

Each

442.0000 8.0000



Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	442	
52693 ✓	142	
54388	300	

8 BR 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issue	Date Issued	Status
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D3791-1

Manufactured

No

230

Each

11.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

51610 ✓

7

Main Warehouse

ST

4

51909

4

AN960C10L

Purchased

No

230

Each

416.0000

38.0000



washer

NAS1149C0332R

QSI 017

Warehouse

Loc Qty

Loc Code

Location

113288

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

316

112116

156

112612

160

38 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issue	Date Issued	Status
D2745		Manufactured	No			230	Each	346.0000	8.0000			

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	59	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST46	287	
51537	70	
51910 ✓	36	
52311	181	

8/10 10-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AX3C5A 		Purchased	No			230	Each	609.0000	34.0000			
Bolt												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST 112641	609	
111424	8	
111707	69	
112314	1	
113121	231	
113149	300	

34. PR 10-01-19.

D3537-1	Manufactured	No				230	Each	141.0000	3.0000			
Wearpad												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	139	
51678 ✓	34	
51679	105	

3 PR 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L		Purchased	No			230	Each	240.0000	1.0000			



WASHER

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST 110372	240	
104093	2	
107520	4	
110139	29	
110584	100	
111424	105	

1 BR 10-01-19.

D3492-043 Manufactured No

230 Each 143.0000 8.0000



Plug Assembly

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	123	
54682	123	
Main Warehouse		
ST	20	
52309 ✓	20	

8 BR 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A BOLT		Purchased	No			230	Each	828.0000	4.0000			

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	828	
111982 ✓	828	

4 BR 10-01-19.

NAS1611-013 O-RING		Purchased	No			230	Each	74.0000	8.0000			
---------------------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	74	
106513	11	
111424	20	
111758 ✓	43	

8 BR 10-01-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25 		Manufactured	No			230	Each	15.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 7

51927 ✓ 7

Main Warehouse

ST 8

52589 8

D3794-1 Manufactured No



Gasket

230 Each 15.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 12

51928 ✓ 12

Main Warehouse

ST 3

46530 1

47212 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,000.000	4.0000			
NUT												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1000	
111424 ✓	8	
112314	992	

H. BK 10-01-19

D3493-1

Manufactured No

260 Each 55.0000 2.0000



Washer

10-1-21

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	55	
44902	2	
47710	53	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21083C8

Purchased

No

260

Each

53.0000

2.0000



10-1-21 SP

NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

110584

5

111424

2

112492

6

113149

40

AN8C21A

Purchased

No

260

Each

148.0000

2.0000



10-1-21 SP

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

148

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

112720

38

113558

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Priority Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960C816L

Purchased

No

260

Each

240.0000

2.0000

WASHER

10-1-2151

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

240

104093

2

107520

4

110139

29

110584

100

111424

105

D3672-1

Manufactured

No

230

Each

1,744.000

4.0000

Phenolic Washer

2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1244

39275

19

42329

5

47628

220

52505

1000

Main Warehouse

ST117

500

51674

500

H. BR 10-01-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:43:40 AM

Work Order ID: 54952



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments: IPP RevP: as per ECN9490 DD 09.12.09 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	----------------	--------

D2741

Manufactured No

260

Each

45.0000

1.0000



Blade, 350 Skidtube

10-1-21 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45

45320

1

47113

4

51931

40

D3532-1

Manufactured No

260

Each

80.0000

2.0000



Spacer

10-1-21 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

80

44904

2

52321

78

D3672-13

Purchased No

260

Each

948.0000

2.0000



Phenolic Washer

10-1-21 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

948

54363

948

2

January 5, 2010 10:43:40 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3531-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN5C4A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-S	NUT
1	1	1	1	MS21083CB	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
 - ACID ETCH, ALONIDE ASSEMBLY PER DART OSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART OSI 005 4.3
 - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART OSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL "F" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 1) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 2) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL **A**
- 3) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. 54952
PA 10-1-05

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08-07-16

F	INCORPORATE DSE 0413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3537-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN S8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/RAFT SADDLE REMOVED (8 P1). WEARSHOE HARDWARE QTY UPDATED (10); D3488-041/-042 HARDWARE UPDATED (ZN C1-e, S, 10, 11); ADD NOTE 12 AND 13 (ZN A8-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D36S1-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HRL; REMOVE D2741, QTY (2) AN960C216; REMOVE QTY (2) MS21083CB	CS	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/5157	PH	08.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	08.11.16
B	CHANGE MS24694-S293 TO AN8-16A	CP	08.09.01
A	NEW ISSUE	DS	08.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, VA		
CHECKED	DRAWING NO.	REV. F	
MFG. APPR.	D2750		SHEET 1 OF 11
APPROVED	TITLE		SCALE
DE APPR.	350 SKIDTUBE ASSEMBLY		NTS
DATE	08.07.16		

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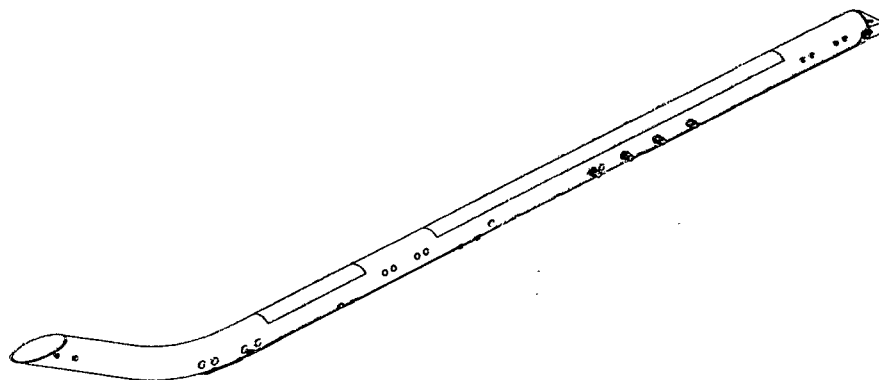
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

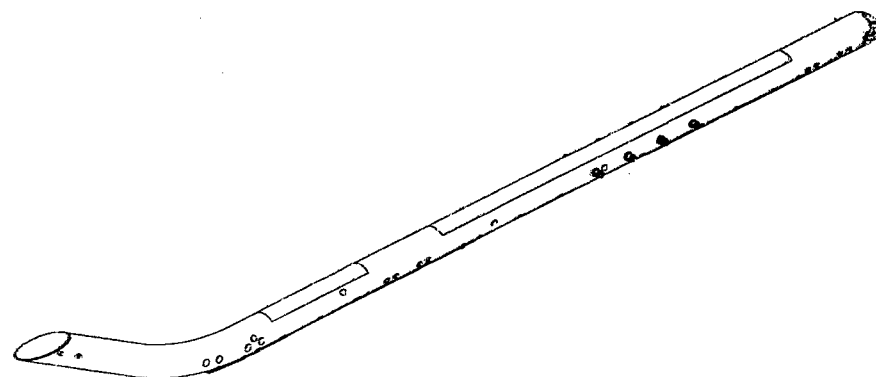
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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SEP 22 1987

W/O 549.52

DESIGN	REV	DART AEROSPACE USA, INC.	
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MFG. APPR.	REV	D2750	SHEET 2 OF 11
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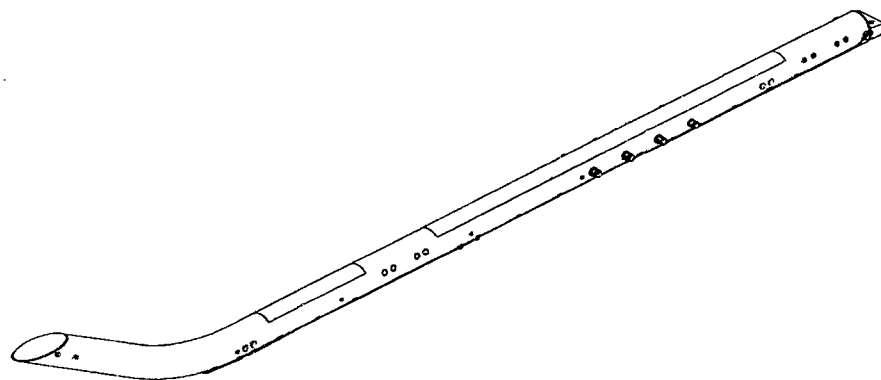
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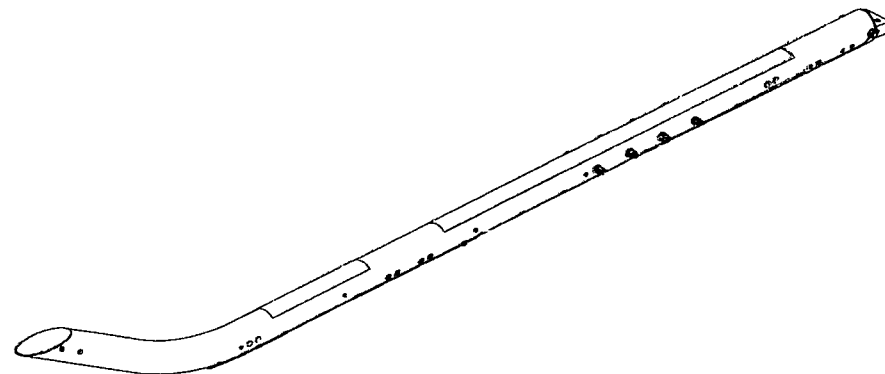
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-11

1010 54952

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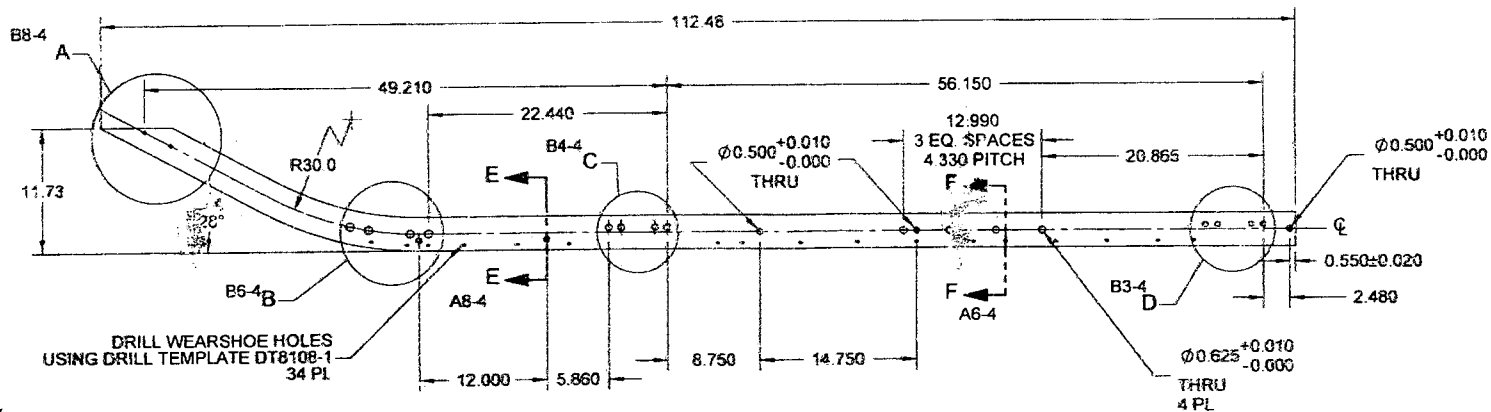
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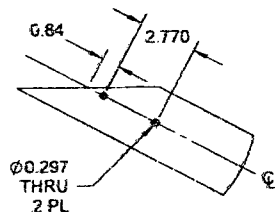
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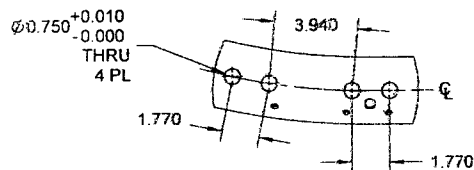
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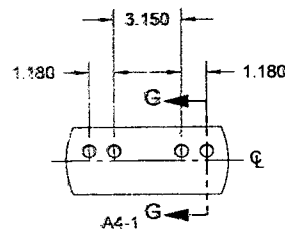
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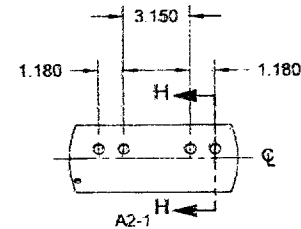
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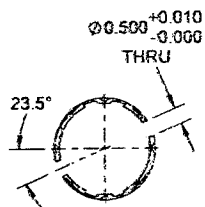
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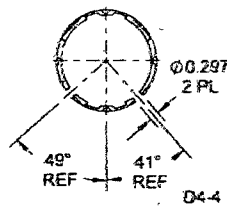
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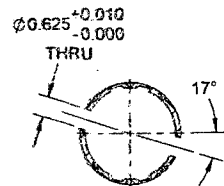
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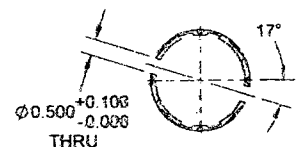
SECTION E-E
SCALE 3X, 2 PL






SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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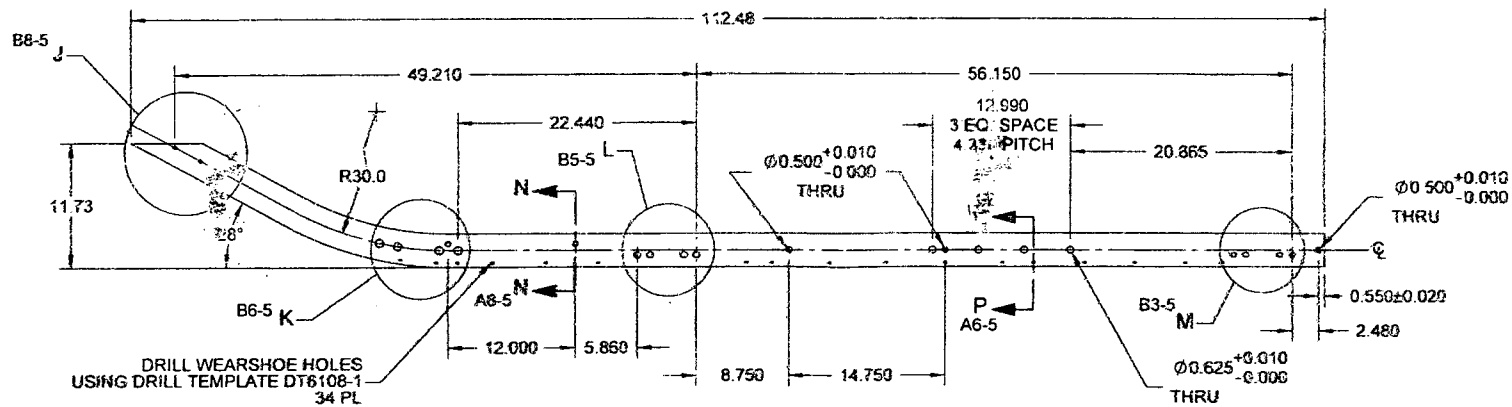
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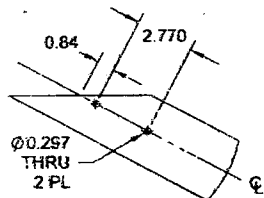
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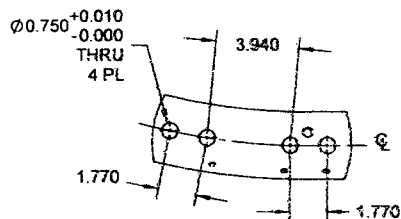
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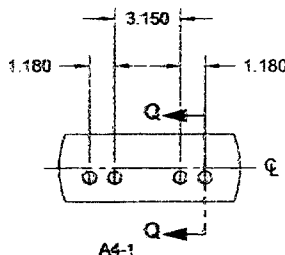
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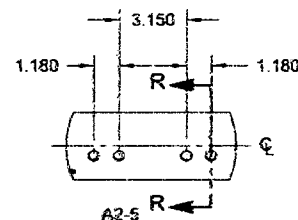
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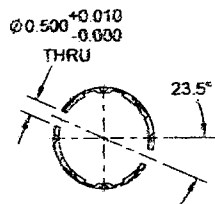
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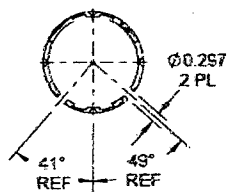
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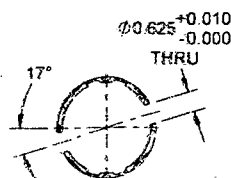
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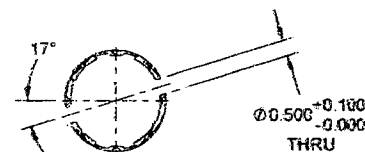
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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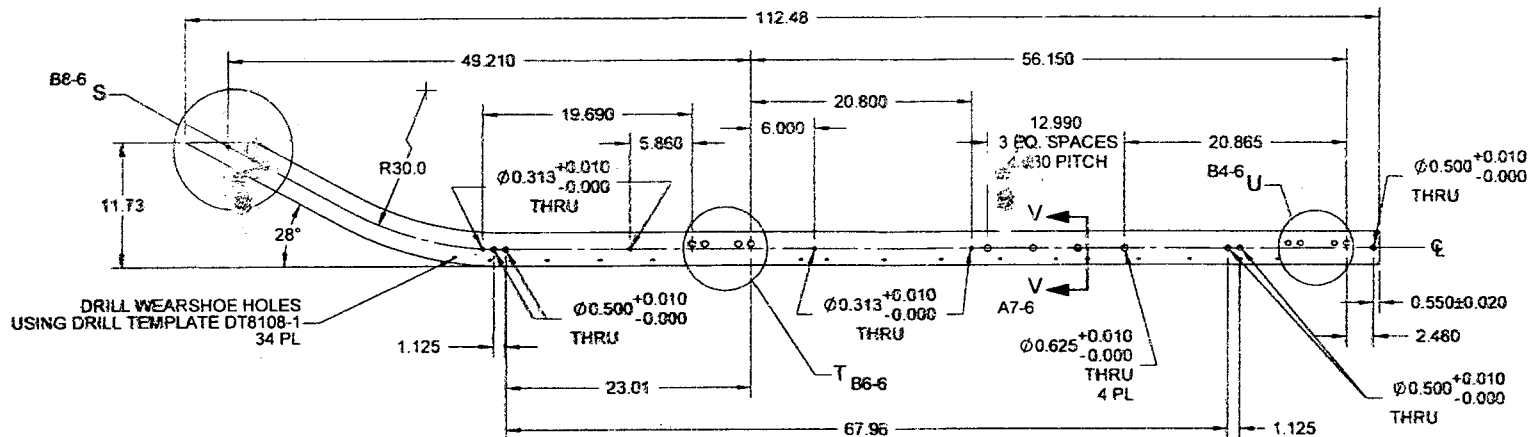
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

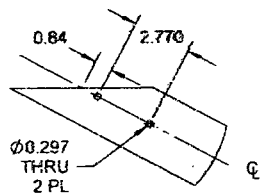
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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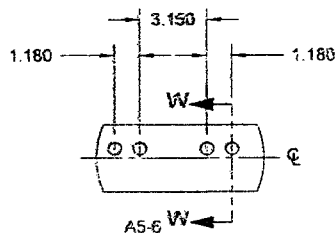
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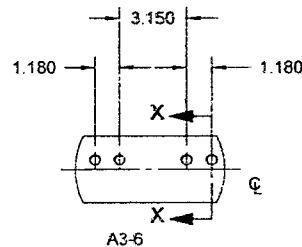
D2750-3 LH SKIDTUBE



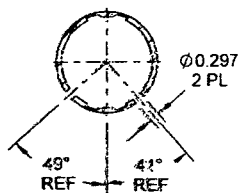
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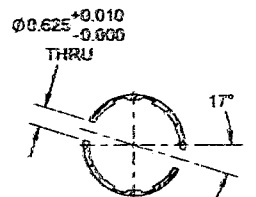
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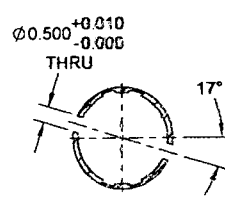
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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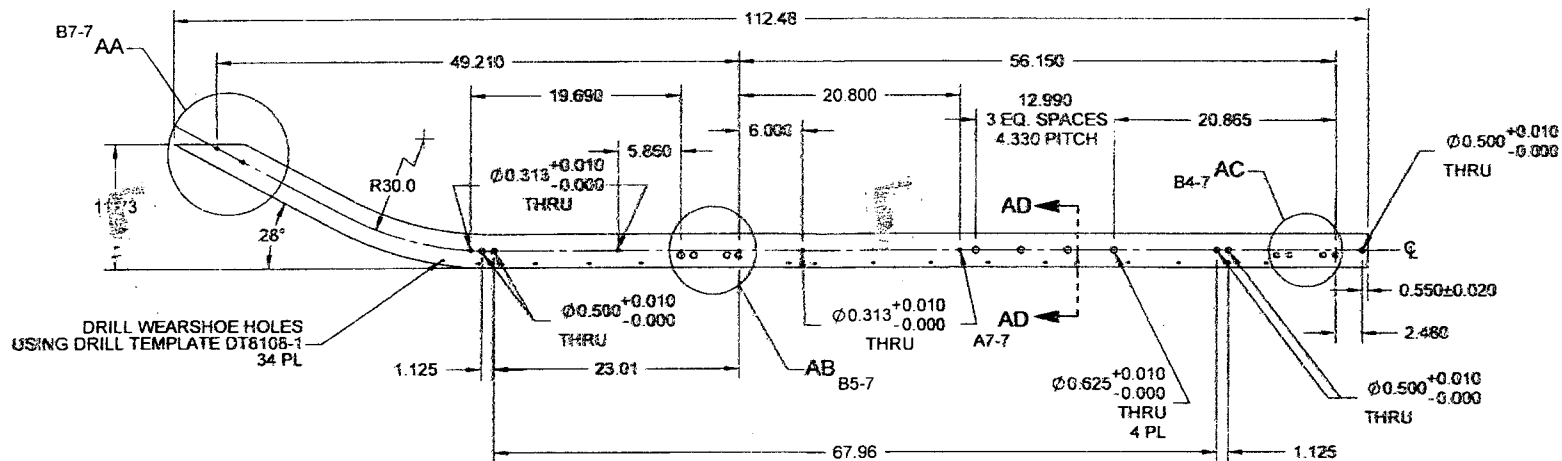
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

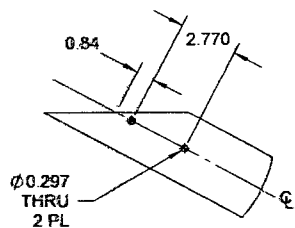
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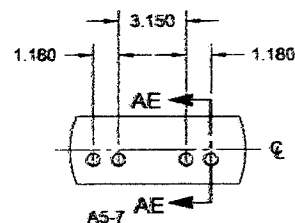
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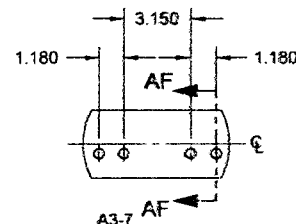
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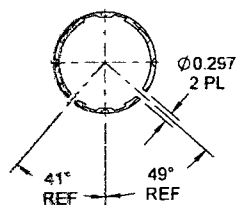
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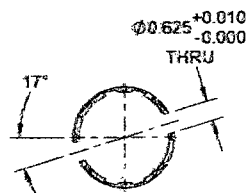
DETAIL AB
SCALE 2X



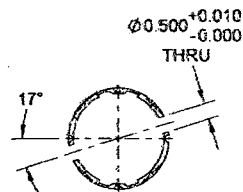
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED

W/O 54952

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	FORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

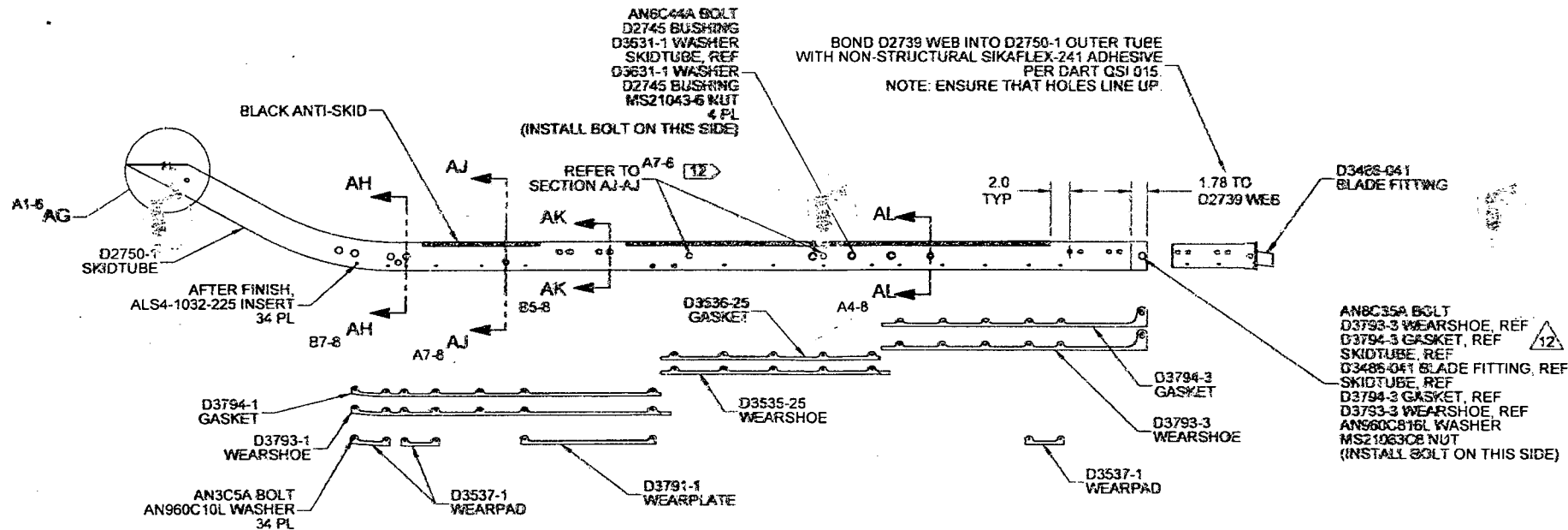
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

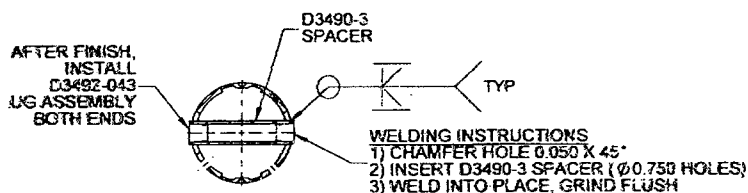
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

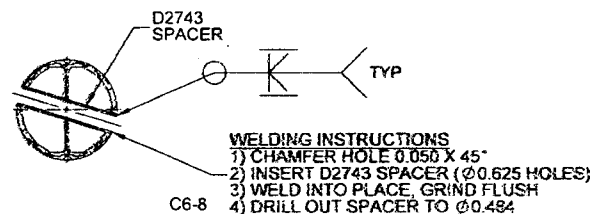
NOTE: Date & initial all entries



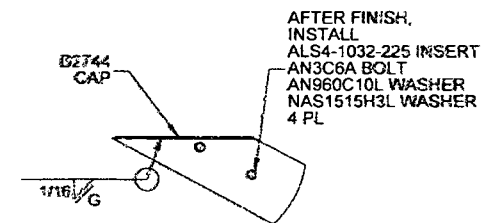
D2750-041 350 SKIDTUBE ASSEMBLY, LH



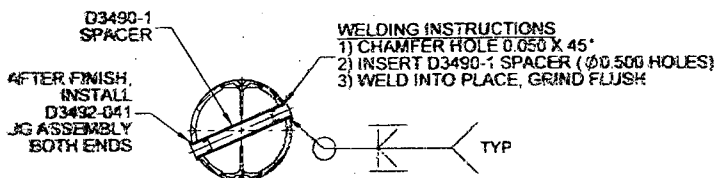
SECTION AH-AH
SCALE 3X, 4 PL



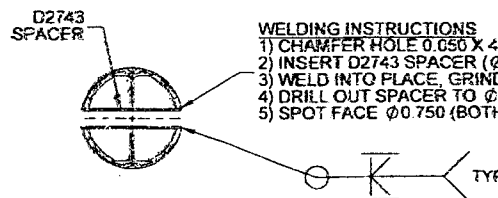
SECTION AK-AK
SCALE 3X, 4 PL



DETAIL AG
SCALE 2X
RELEASED



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	110 54952	DART AEROSPACE USA, INC.	REV. F
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	SHEET 6 OF 11
MFG. APPR.		TITLE	SCALE
APPROVED		350 SKIDTUBE ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 1990 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

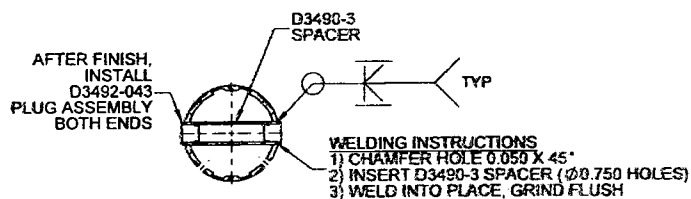
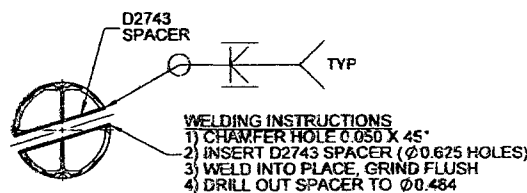
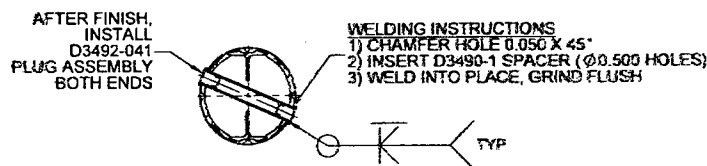
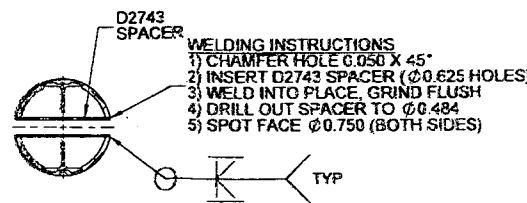
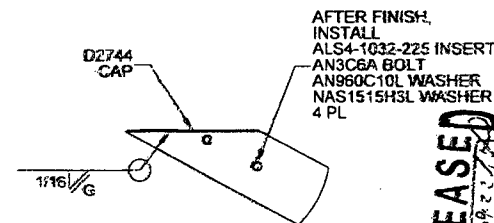
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

A1-9
AM

BLACK ANTI-SKID

(INSTALL NUT ON THIS SIDE)

REFER TO
SECTION AP-APBOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.1.78 TO
D2739 WEBD3488-042
BLADE FITTINGAN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
D3488-042 BLADE FITTING, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)**D2750-042 350 SKIDTUBE ASSEMBLY, RH****SECTION AN-AN**
SCALE 3X, 4 PL**SECTION AQ-AQ**
SCALE 3X, 4 PL**SECTION AP-AP**
SCALE 3X, 4 PL**SECTION AR-AR**
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)**DETAIL AM**
SCALE 2X

DESIGN	W/0 54432	DART AEROSPACE USA, INC.	REV. F
DRAWN	W/0 54432	PORT HADLOCK, WA	SHEET 9 OF 11
CHECKED	W/0 54432	D2750	SCALE
MFG. APPR.	W/0 54432	TITLE	350 SKIDTUBE ASSEMBLY
APPROVED	W/0 54432	DATE	06.07.16
DE APPR.	W/0 54432		
DATE	06.07.16		

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06-06-2007

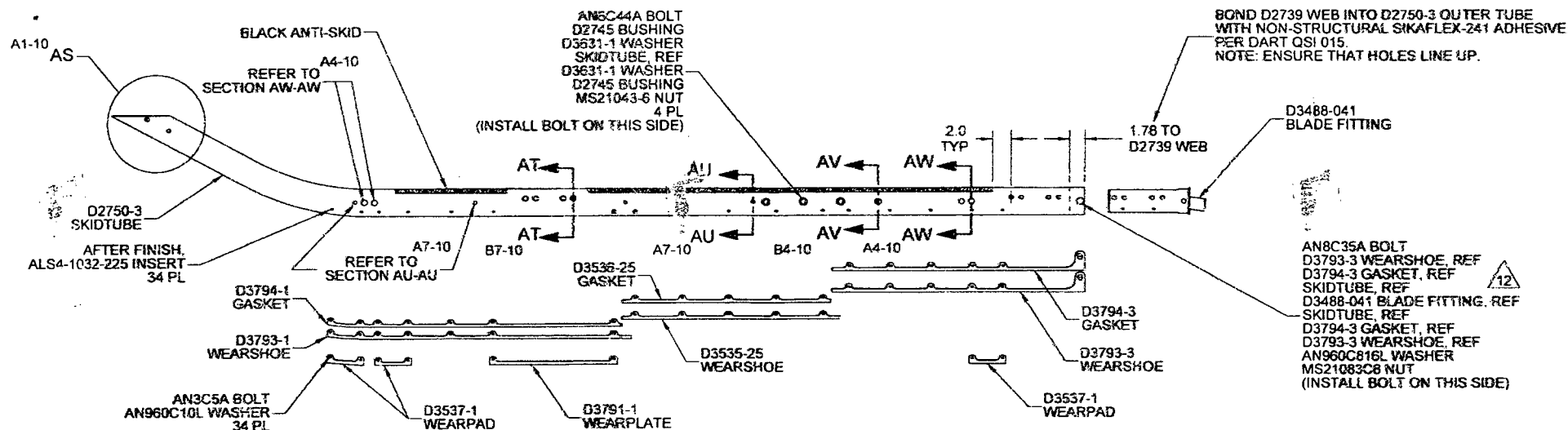
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

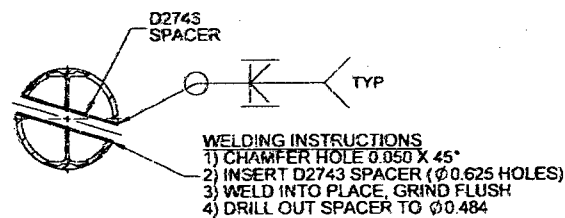
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

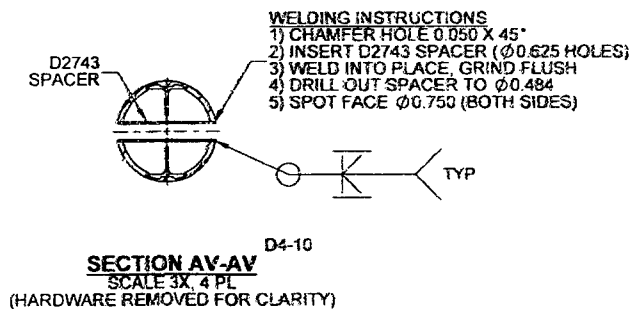
NOTE: Date & initial all entries



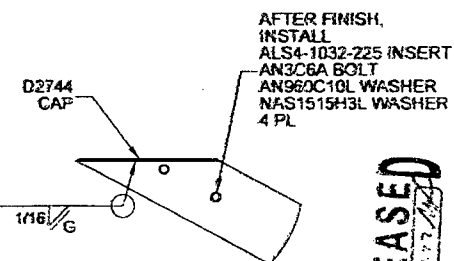
D2750-043 350 SKIDTUBE ASSEMBLY, LH



SECTION AT-AT
SCALE 3X, 4 PL

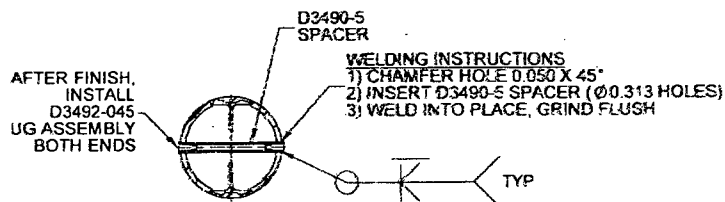


SECTION AV-AV
SCALE 3X, 4 PL

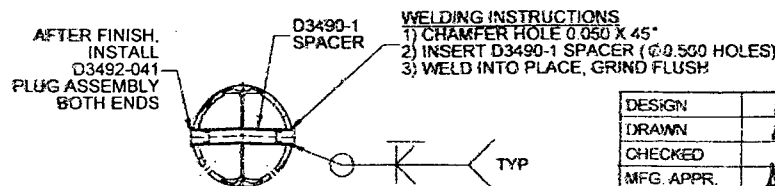


DETAIL AS
SCALE 2X







RELEASED



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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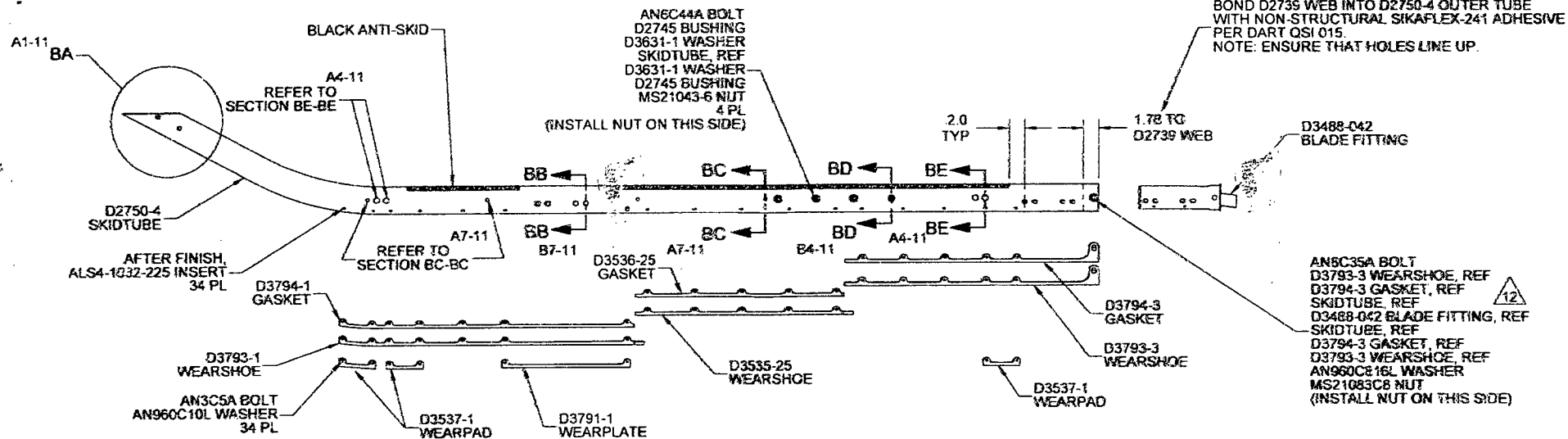
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

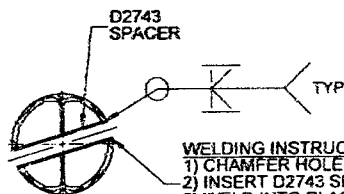
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

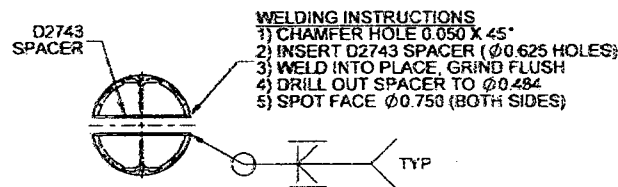


D2750-044 350 SKIDTUBE ASSEMBLY, RH

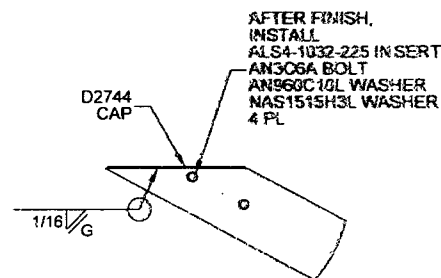
RELEASED
68-07-22/100



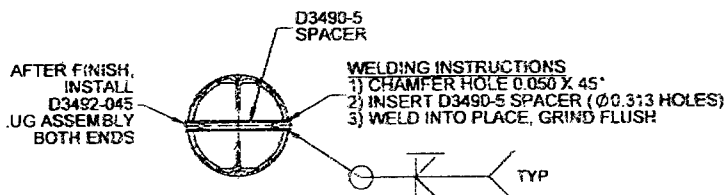
SECTION BB-BB
SCALE 3X, 4 PL



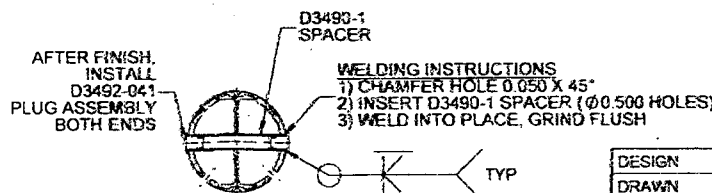
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

DESIGN	<i>410 54952</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>410 54952</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>410 54952</i>	D2750	SHEET 11 OF 11
APPROVED	<i>410 54952</i>	TITLE	SCALE
DE APPR.	<i>410 54952</i>	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54956
Part number: D350-636 012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dn. Date of Test Coupon 10.01.11

Welder Barclay Elliott Date of Test Coupon 10-01-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld